

Date: Thursday, 11/16/2006 4:26:05 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HANDLE WELDMENT
<b>Job Number</b> : 29493	
<b>Estimate Number</b> : 12089	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D3355041
<b>This Issue</b> : 11/16/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D3355 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 26806	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 12/10/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : est rev A 98.01.23 new issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	VA2160	SNAP BUTTON
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 SNAP BUTTON batch: *M17355*

*CPL 07.01.08*

(4)

2.0	GP1R	Black Vinyl Grip
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Black Vinyl Grip batch: *M16871*

*CPL 07.01.08*

(4)

3.0	D3355047	ADJUSTABLE EXTENSION
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 ADJUSTABLE EXTENSION batch: *B29523*

*CPL 07.01.08*

(4)

4.0	D3355045	BOTTOM PART
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 BOTTOM PART batch: *B29522*

*CPL 07.01.08*

(4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Assemble as per dwg D3355

*CPL 07.01.08*

(4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 11/16/2006 4:26:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 29493

Part Number: D3355041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/01/08* (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51366*

*CP 07/01/09* (4) *07/01/09*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/01/10*

Job Completion



*07/01/10*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

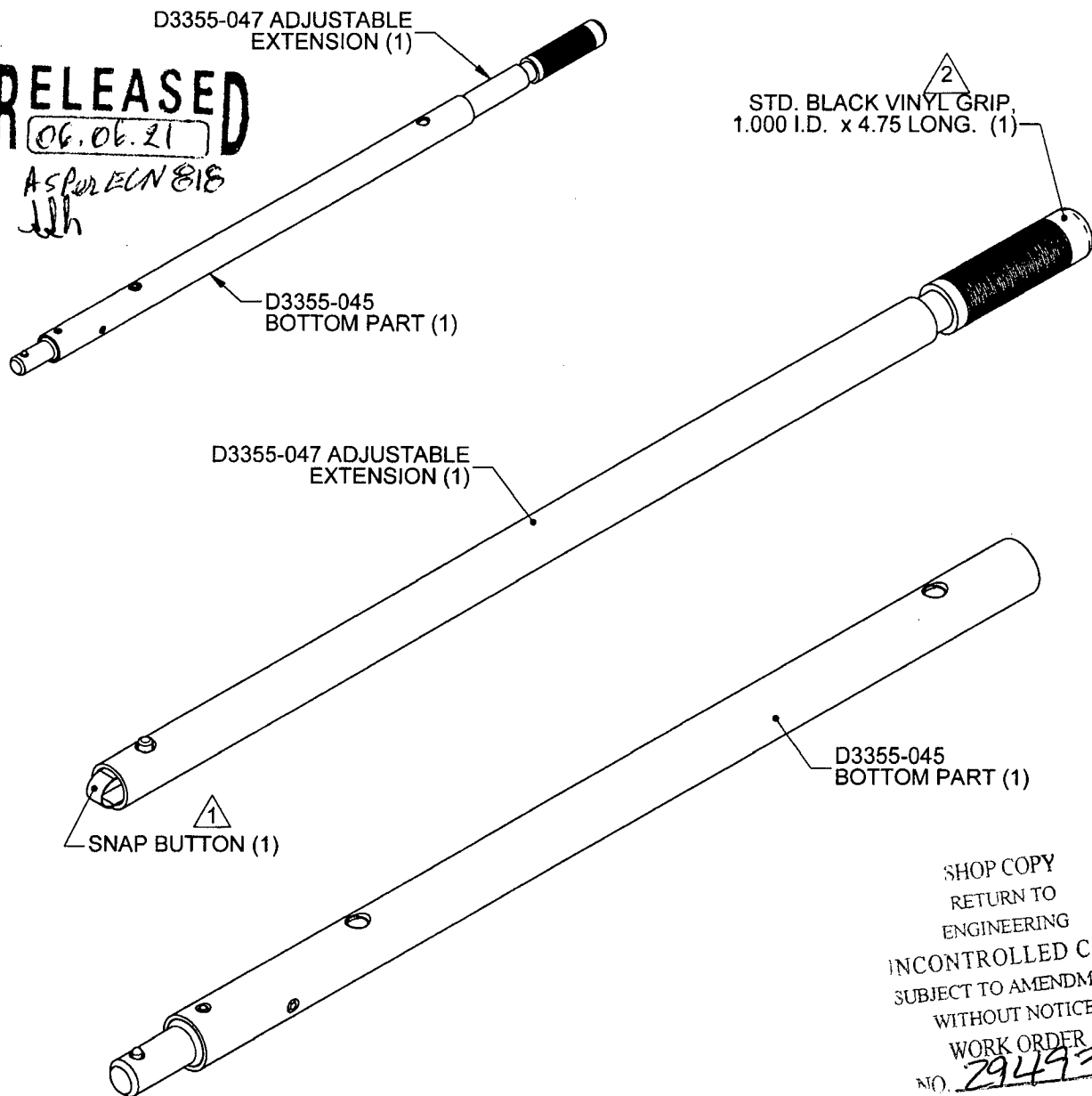
**NOTE:** Date & initial all entries

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DATE <b>06.05.31</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

**RELEASED**  
06.06.21

AS PER ECN 818  
*[Signature]*



**D3355-041 HANDLE ASSEMBLY**

**NOTES:**

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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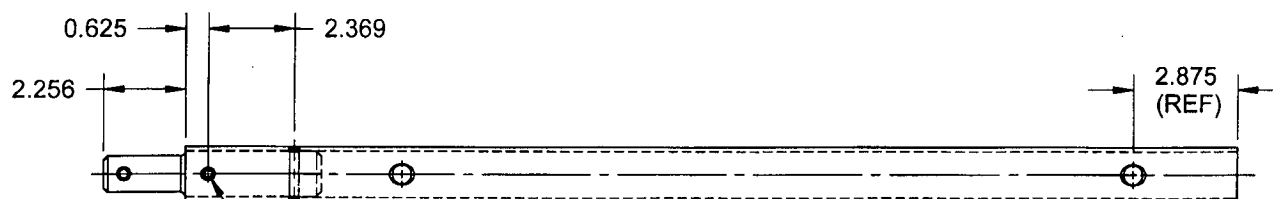
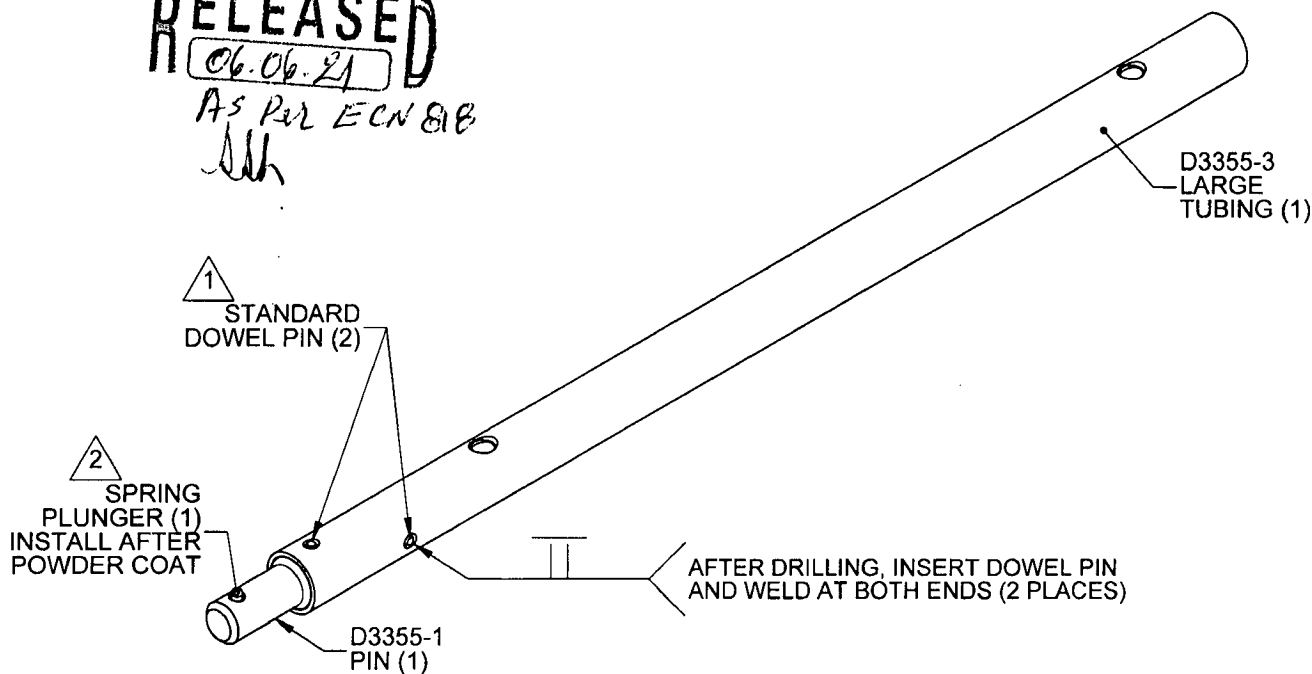


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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*[Signature]*



### D3355-045 BOTTOM PART

#### NOTES:

- 1) STEEL STANDARD GROUND DOWEL PIN,  $\varnothing 0.250 \times 1.50$  LONG  
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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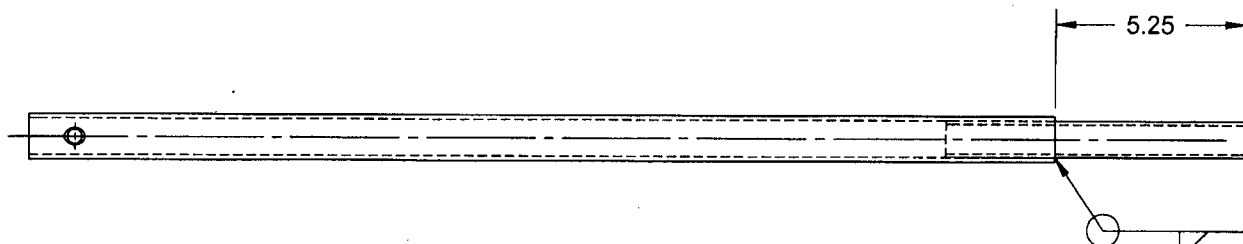
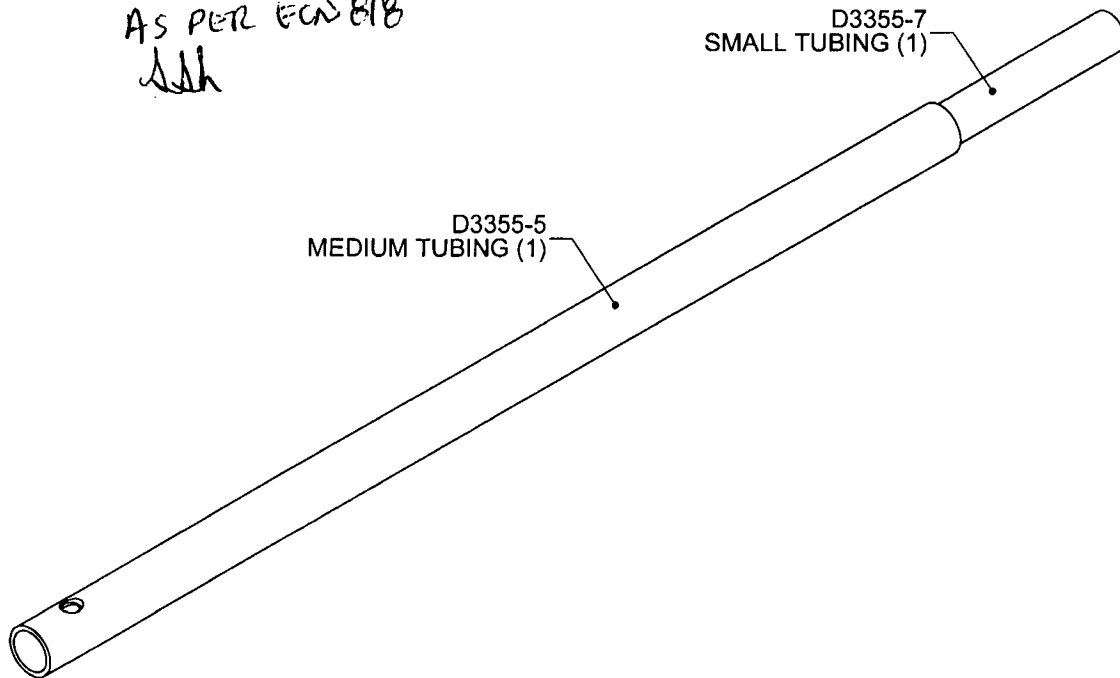
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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*[Signature]*



**D3355-047 ADJUSTABLE EXTENSION**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

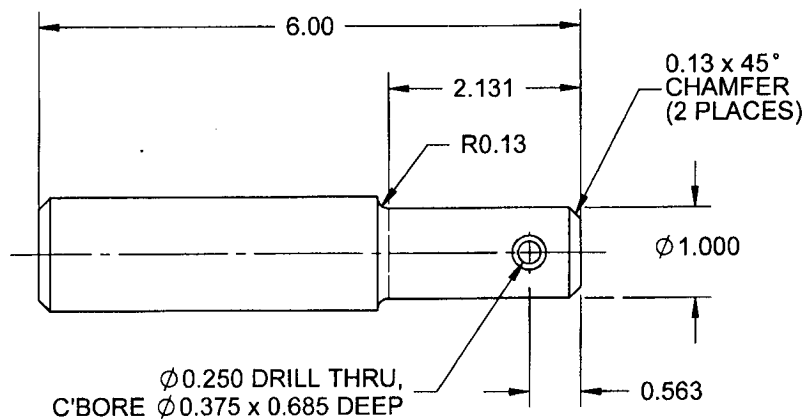
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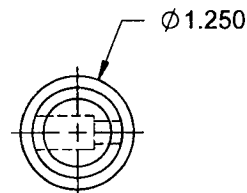
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:2



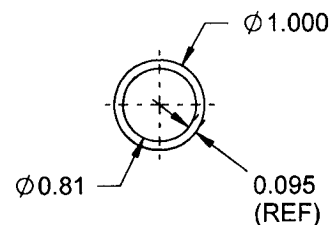
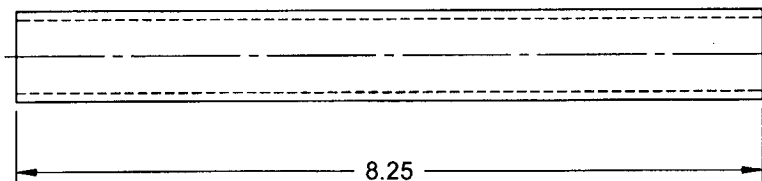
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### **D3355-1 PIN**

#### **D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



### **D3355-7 SMALL TUBING**

#### **D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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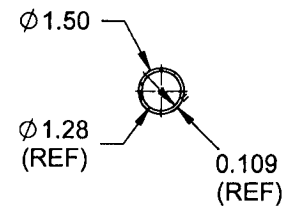
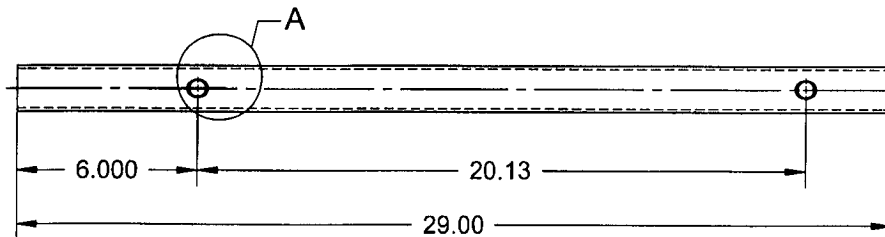
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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:6

CHAMFER  $\phi 0.687$  (11/16)  
x 45°, 0.060 DEEP  
(2 PLACES)

$\phi 0.531$  (17/32) DRILL  
THRU (2 PLACES)

**DETAIL A**  
SCALE 1 : 2



### **D3355-3 LARGE TUBING**

#### **NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

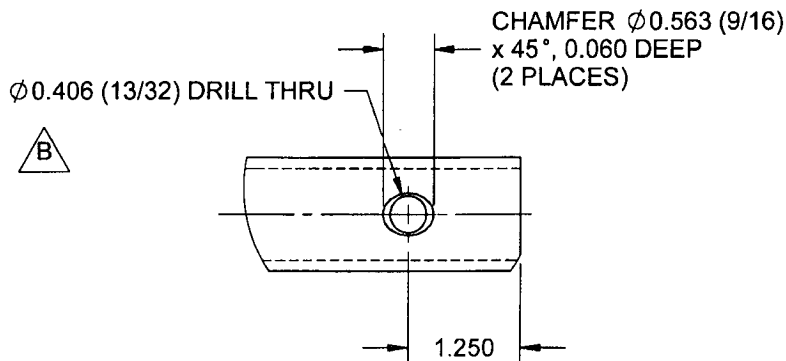
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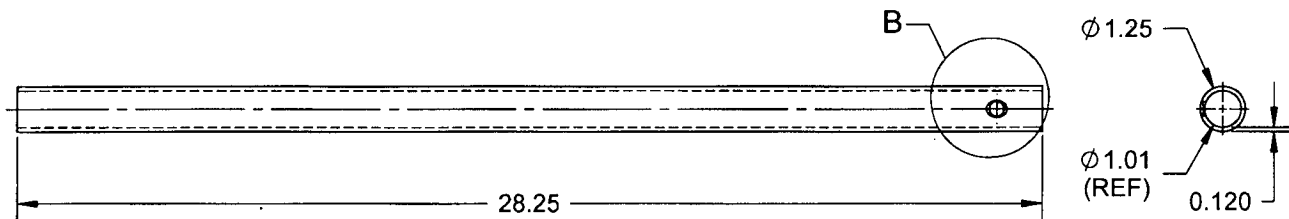
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DATE <b>06.05.31</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5



**DETAIL B  
SCALE 1 : 2**



**D3355-5 MEDIUM TUBING**

**NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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